

Ship May 18

Work Order ID 84272

84272

Page 1

May-08-12 3:58:10 PM

Item ID: D4545-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Retainer, Inner, LH (Side)

Start Date: 08/05/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/08 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4545	<u>B</u> <u>MD</u>								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1- ASSEMBLE AND BEND TABS AS PER DWG								
	2- DISASSEMBLE AND DEBURR								
	3- DIMPLE HOLES AS PER DWG								

SB 12/05/14

③

SB 12/05/14

③

3

SB 12/05/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84272

May-08-12 3:58:10 PM

84272

Page 2

Item ID: D4545-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Retainer, Inner, LH (Side)
 Start Date: 08/05/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 22/05/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				3			12-05-14
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				3x	6		12-05-14
140 *140* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				3	4		12-5-14

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Packaging

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Page 4

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Item ID: D4545-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Retainer, Inner, LH (Side)
 Start Date: 08/05/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 22/05/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

12/5/16
 MF 12-05-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

May-08-12 3:58:14 PM

Page 1

Work Order ID: 84272

84272

Parent Item: D4545-043

D4545-043

Parent Item Name: Retainer, Inner, LH (Side)

Start Date: 08/05/2012

Required Date: 22/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.01.13 new issue DD verf:JLM IPP REV:B
12.02.27 AS PER DWG REV.B DD VERF:EC IPP REV:C 12.05.08
as per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4541-3		Manufactured	No			100	Each	4.0000	1	2			
D4541-3									**			80 12/05/16	
Bracket													

Location	Loc Qty	Loc Code
FG	2	D 84404
78276	2	
GA	2	
81262	2	

D4542-3		Manufactured	No			100	Each	5.0000	1	2			
D4542-3									**			80 12/05/15	
Retainer, Inner													

Location	Loc Qty	Loc Code
FG	2	B 84404
78280	2	
GA	3	
81267	3	

MS20426AD3-4		Purchased	No			145	Each	3,280.000	28	56			
MS20426AD3-4									**			84 12/05/15	
RIVET													

Location	Loc Qty	Loc Code
ST316	3280	
104374	614	
110398	2666	

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Picklist Print

May-08-12 3:58:14 PM

Page 2

Work Order ID: 84272

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Parent Item: D4545-043

D4545-043

Parent Item Name: Retainer, Inner, LH (Side)

Start Date: 08/05/2012

Required Date: 22/05/2012

Start Qty: 2.00

Required Qty: 2.00

MS21059L3K

Purchased

No

145

Each

314.0000

14

28

MS21059L 3K

Nutplate

**

PS 12/05/15
42

Location

Loc Qty

Loc Code

ST302

314

121114

314

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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ITEM	QTY -041	QTY -042	QTY -043	QTY -044	QTY -045	QTY -046	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
	X								D4545-041	RETAINER, LH INNER (LOWER)
		X							D4545-042	RETAINER, RH INNER (LOWER)
			X						D4545-043	RETAINER, LH INNER (SIDE)
				X					D4545-044	RETAINER, RH INNER (SIDE)
					X				D4545-045	RETAINER, LH INNER (TOP CORNER)
						X			D4545-046	RETAINER, RH INNER (TOP CORNER)
							X		D4545-047	RETAINER, LH INNER (TOP)
								X	D4545-048	RETAINER, RH INNER (TOP)
1	1								D4541-1	BRACKET
2		1							D4541-2	BRACKET
3			1	1					D4541-3	BRACKET
4					1	1			D4541-5F	BRACKET
5							1	1	D4541-7	BRACKET
6	1								D4542-1	RETAINER
7		1							D4542-2	RETAINER
8			1	1					D4542-3	RETAINER
9					1	1			D4542-5	RETAINER
10							1	1	D4542-7	RETAINER
11	40	38	28	28	12	12	16	16	MS20426AD3-4	RIVET
12	19	18	14	14	6	6	8	8	MS21059L3K	NUTPLATE
13	1	1							MS21061L3K	NUTPLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 84272 MCT
12/05/08

RELEASED
2012-05-07

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: AFTER FORMING AND PRIOR TO ASSEMBLY, CHEMICAL CONVERSION COAT D4541-X & D4542-X PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: -041/-042 = 0.38 lbs, -043/-044 = 0.27 lbs,
-045/-046 = 0.11 lbs, -047/-048 = 0.15 lbs
- 8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC..) VALUE

C	CHG FINISH (ZN A8-1); D4541-5F WAS -5 (C4-1) REMOVE TRANSFER DRILL NOTES	CP	12.04.20
B	ADD FINISH (ZN A8-1)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.04.20		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4545	REV. C SHEET 1 OF 9
TITLE RETAINER, INNER	SCALE NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

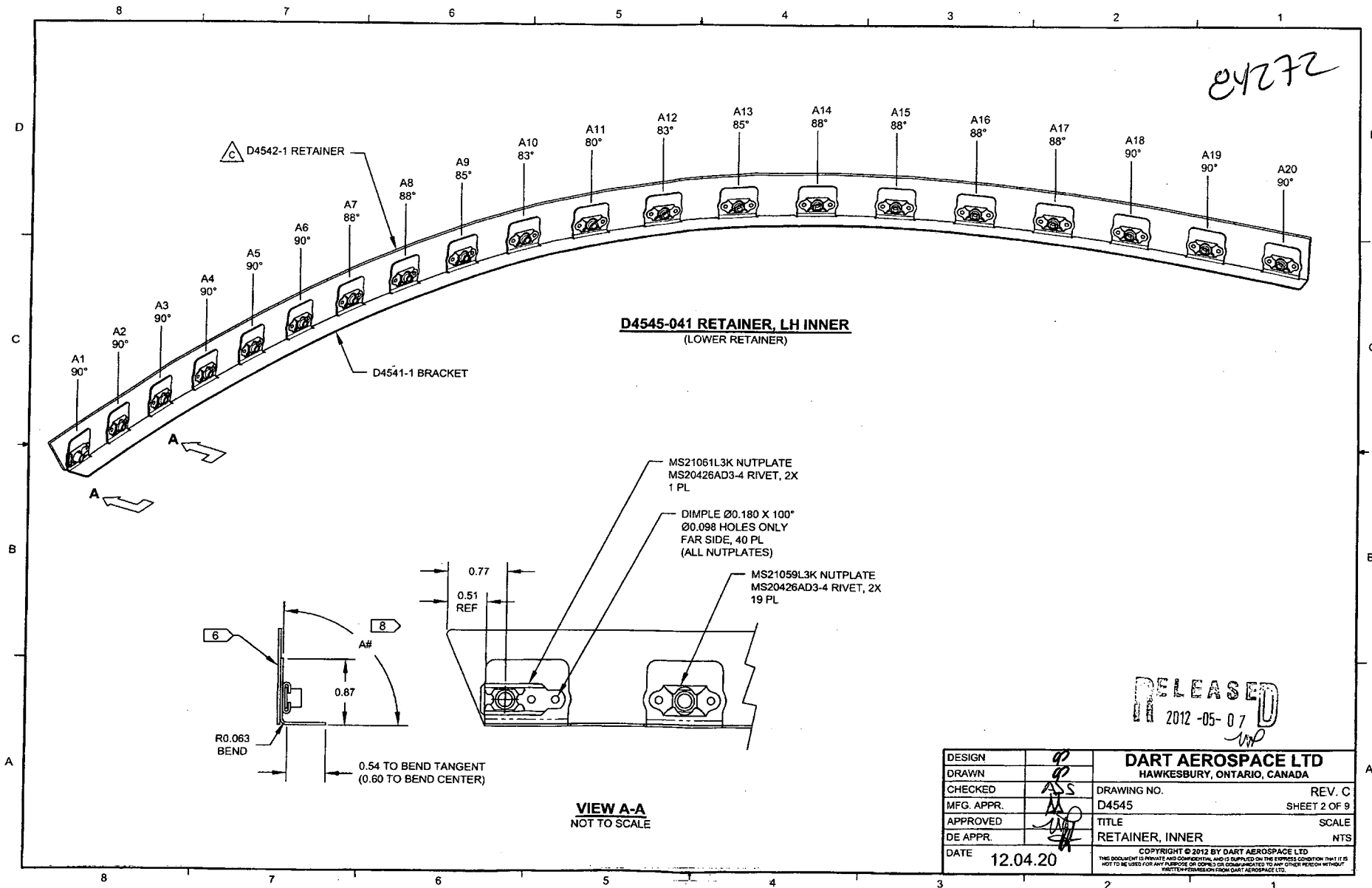
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

04272



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2012-05-07

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Dart Aerospace Ltd

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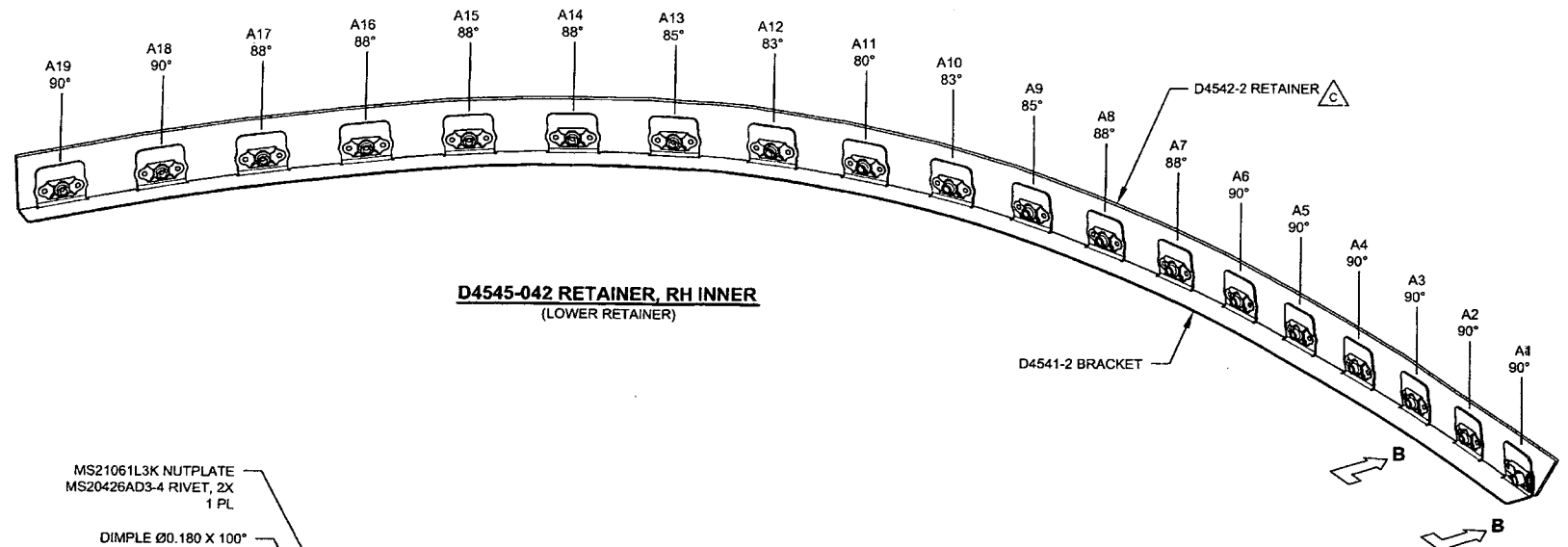
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

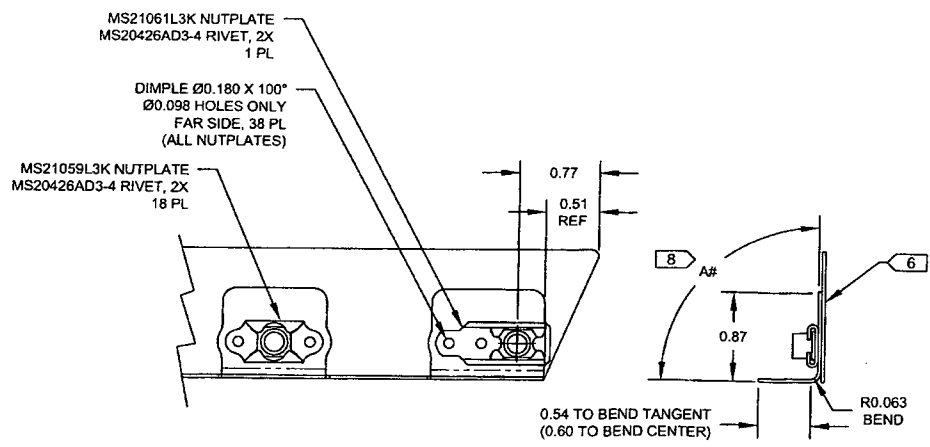
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NOTE: Date & initial all entries

24272



D4545-042 RETAINER, RH INNER
(LOWER RETAINER)



VIEW B-B
NOT TO SCALE

2012-05-07

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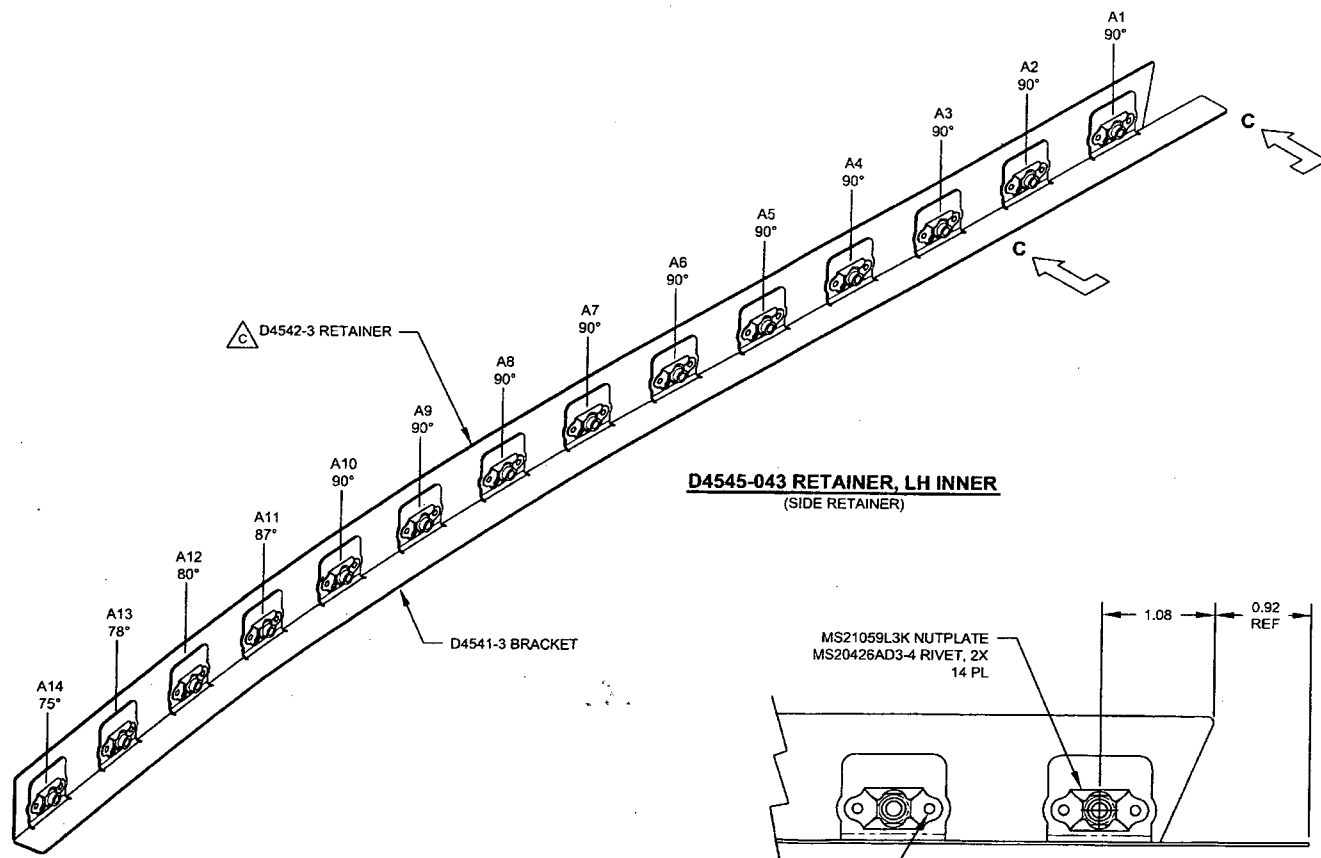
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

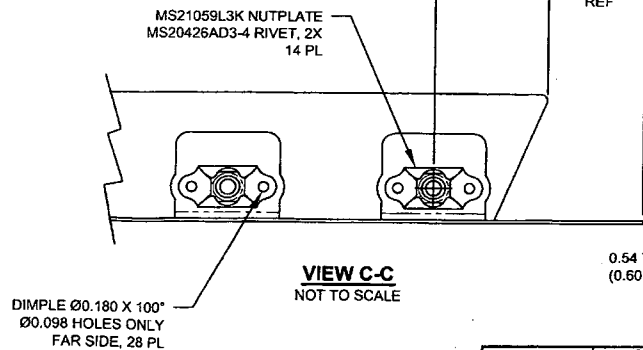
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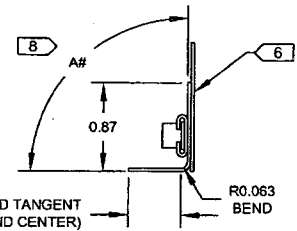
84272



D4545-043 RETAINER, LH INNER
(SIDE RETAINER)



VIEW C-C
NOT TO SCALE



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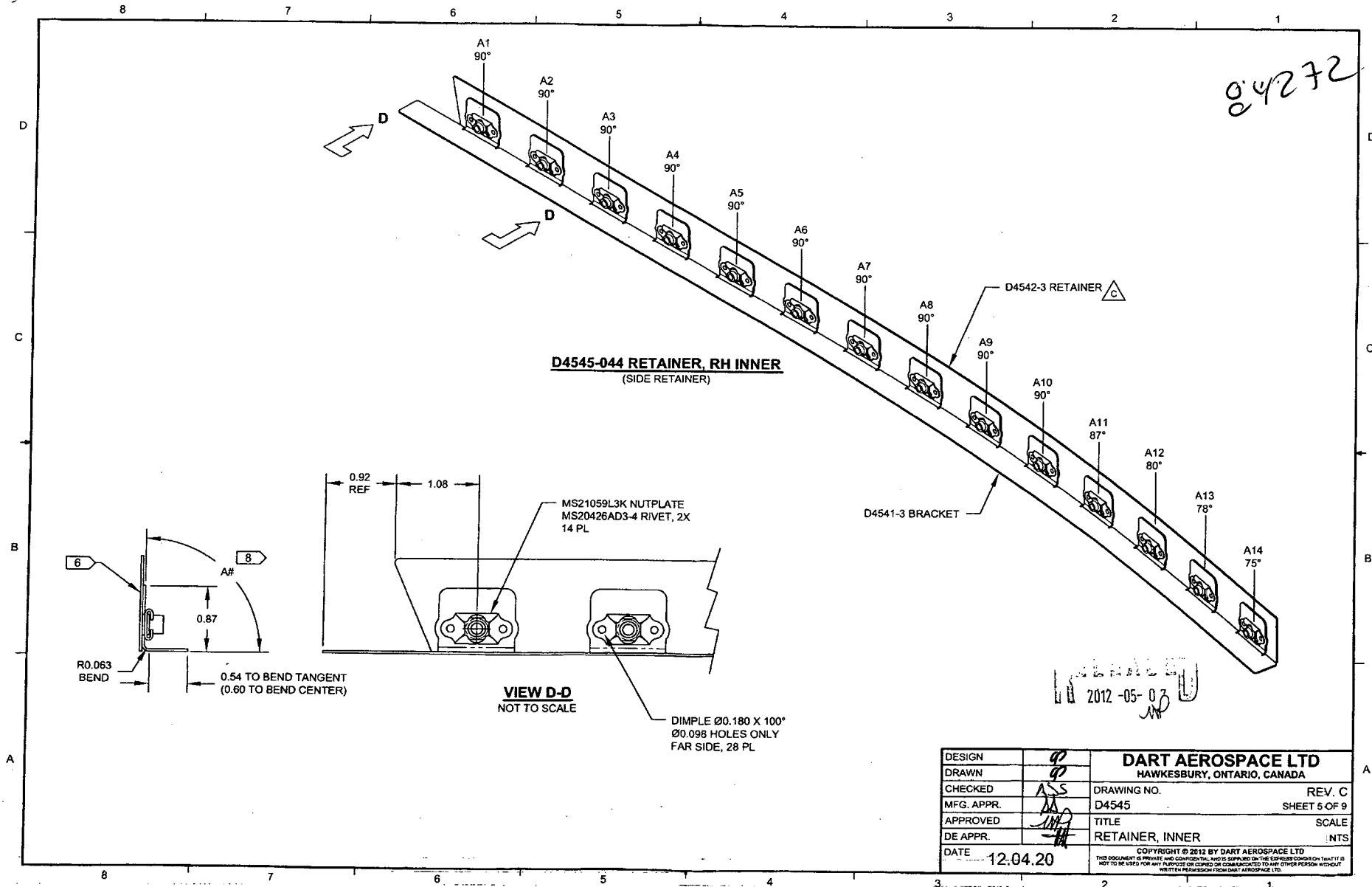
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04272



D4545-044 RETAINER, RH INNER
(SIDE RETAINER)

VIEW D-D
NOT TO SCALE

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 28 PL

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	MA	D4545	SHEET 5 OF 9
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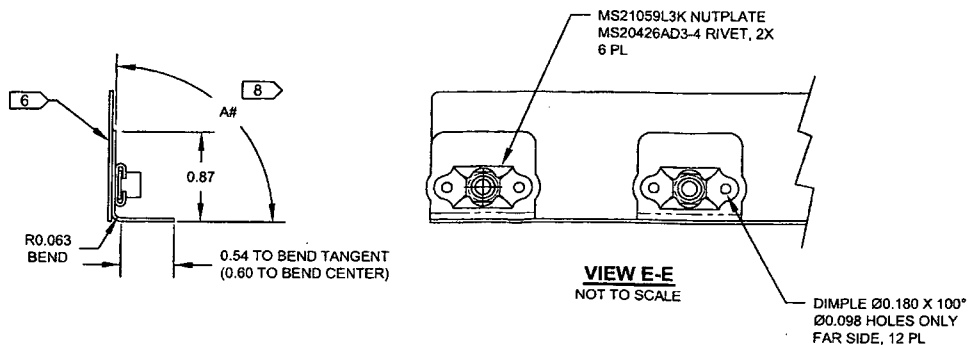
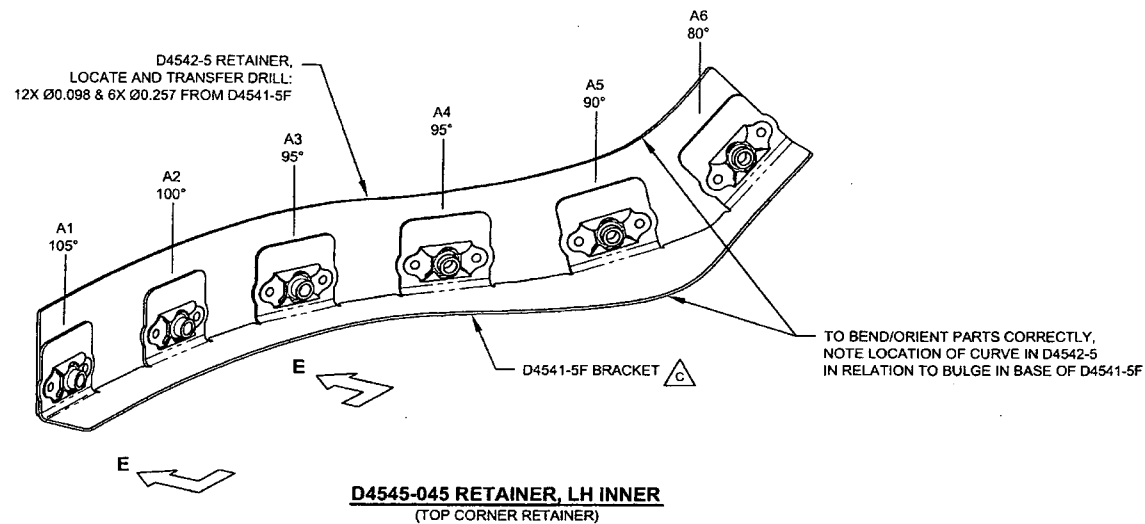
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042.72



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MFG. APPR.	AS	D4545	SHEET 6 OF 9
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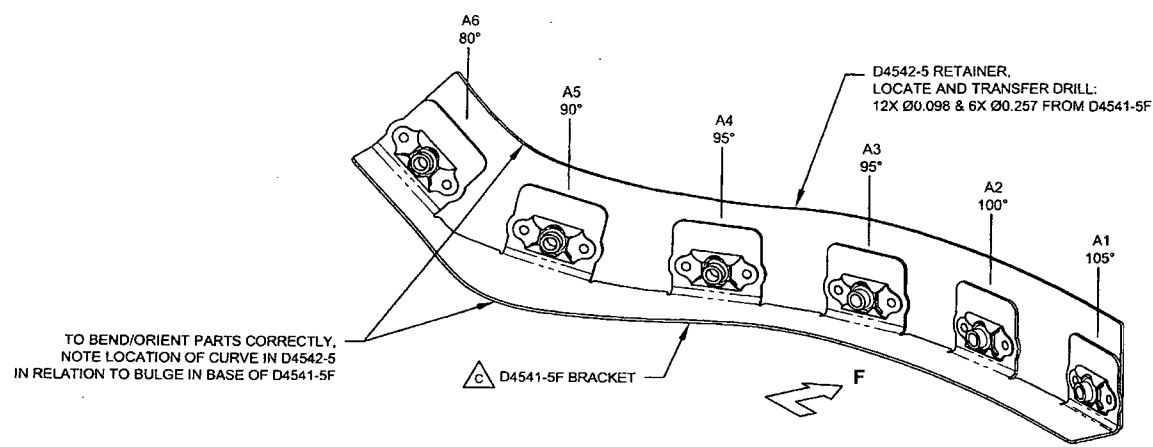
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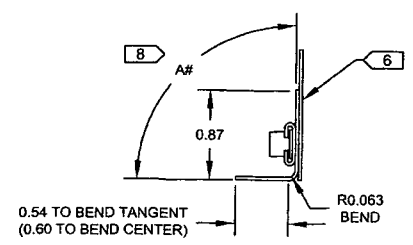
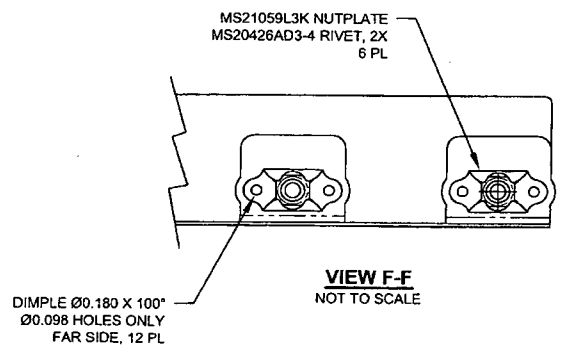
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24272



D4545-046 RETAINER, RH INNER
(TOP CORNER RETAINER)



RELEASED
2012-05-07
JMP

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DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D4545	SHEET 7 OF 9
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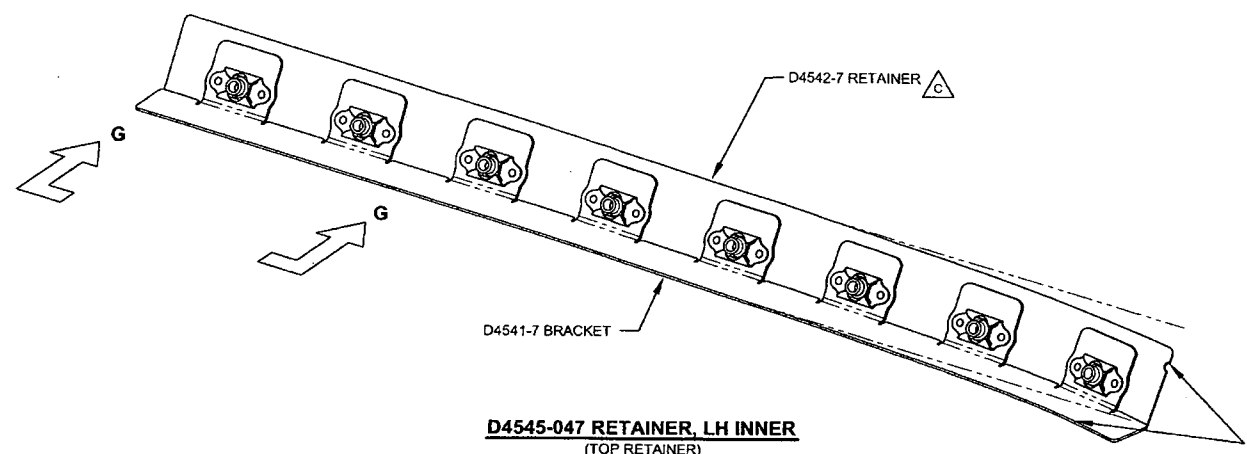
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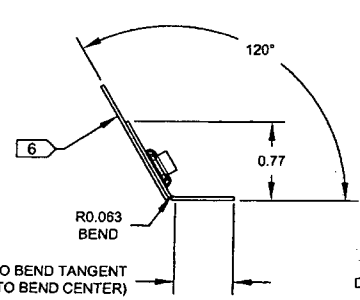
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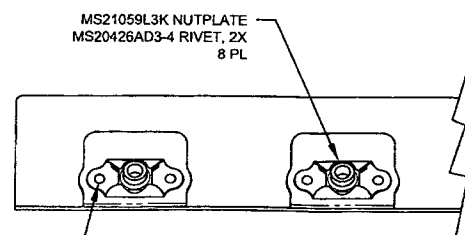


D4545-047 RETAINER, LH INNER
(TOP RETAINER)

TO BEND/ORIENT PARTS CORRECTLY,
NOTE LOCATION OF TOOLING MARK IN D4542-7
IN RELATION TO CURVE IN BASE OF D4541-7



0.56 TO BEND TANGENT
(0.60 TO BEND CENTER)



MS21059L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
8 PL

VIEW G-G
NOT TO SCALE

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 16 PL

RELEASE
2012-05-03

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	MA	D4545	SHEET 8 OF 9
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	RETAINER, INNER	NTS
DATE	12.04.20	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84232

TO BEND/ORIENT PARTS CORRECTLY,
NOTE LOCATION OF TOOLING MARK IN D4542-7
IN RELATION TO CURVE IN BASE OF D4541-7

△ D4542-7 RETAINER

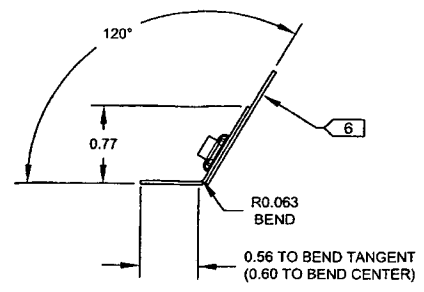
D4541-7 BRACKET

D4545-048 RETAINER, RH INNER
(TOP RETAINER)

MS21059L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
8 PL

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 16 PL

VIEW H-H
NOT TO SCALE



2012-05-07
WJP

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO. D4545	REV. C
MFG. APPR.	AD	SHEET 9 OF 9	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries